

## IN THE CLAIMS

Please amend Claim 24 as follows:

24. (Amended) A method of injection molding a light metal alloy comprising the steps of:

cooling a molten metal under shearing by an extrusion screw into a semi-solidified slurry in a substantially vertical chamber;

discharging the semisolidified slurry from a discharge port at the lower end of the chamber;

turning the semi-solidified slurry in the horizontal direction; and

injecting the turned semi-solidified slurry into molding plates opening or closing in the horizontal direction.

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## REMARKS

Favorable reconsideration of the present application is respectfully requested.

Claims 1-24 remain active in the application.

The invention is directed to a method and apparatus for injection molding a light metal alloy. It has been known to extrude light metal alloys in a vertically oriented screw extruder. The vertical orientation of the extruder minimizes pore formation and abrasion (see pages 1 and 2 of the specification). However, vertical extruders require a large vertical height, and are inherently unstable.

According to a feature of the invention as set forth in the claims, an injection molding apparatus incorporates a substantially vertically extending screw extruder, and so profits from the advantages inherent in vertically oriented screw extruders for molten metal, e.g., uniform crystal grains, reduced pore formation and reduced abrasion or flexion of the extrusion screw